

Work Order ID 131260

AAP

131260

Page 1

April-01-15 1:03:16 PM

Item ID: D4354-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 4/01/15 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 4/07/15 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:

Process Plan: u

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4354

b

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg (D4354-1)

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(4)

04/15/04/01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(4)

04/15/04/01

Work Order ID 131260

April-01-15 1:03:16 PM

131260

Page 2

Item ID: D4354-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw Wearplate Assembly
 Start Date: 4/01/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/07/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							38 9-89
120									
QC	Memo	0.00							
Quality Control									

APR 02 2015

130		0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1- Weld cups as per dwg A/R S.S. ROD BATCH: <u>M123823</u>								
	2- Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: <u>M129684</u>								

x4 15-05-28 MAL

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

4 15-6-2 DAS 50 38 9-89

Work Order ID 131260

131260

Page 3

April-01-15 1:03:16 PM

Item ID: D4354-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw Wearplate Assembly
 Start Date: 4/01/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/07/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									DAS
QC	Memo	0.00				4	15-6-2		50
Quality Control									9-89
160	Identify as per dwg & Stock Location: <u>ST6006</u>	0.00							
160									
Packaging	Memo	0.00				4x	DAS	JUN 0 2 2015	
Packaging							28		9-89
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ JUN 0 3 2015

Picklist Print

April-01-15 1:03:16 PM

Page 1

Work Order ID: 131260

131260

Parent Item: D4354-041

D4354-041

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 4/01/15

Required Date: 4/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1		Manufactured	No			130	Each	25.0000	10	40			

D4379-1

Wearplate Cup

B131032 x 40

Location

Loc Qty

Loc Code

WA002

25

129938

25

x40

15-05-28 MAL

M304S16GA

Purchased

No

100

sf

454.8176

0.9223

4

M304S16GA

304/316 Sheet .063

02/15/04/01

Location

Loc Qty

Loc Code

MAT019

454.8176

m131384

195.8176

m131503

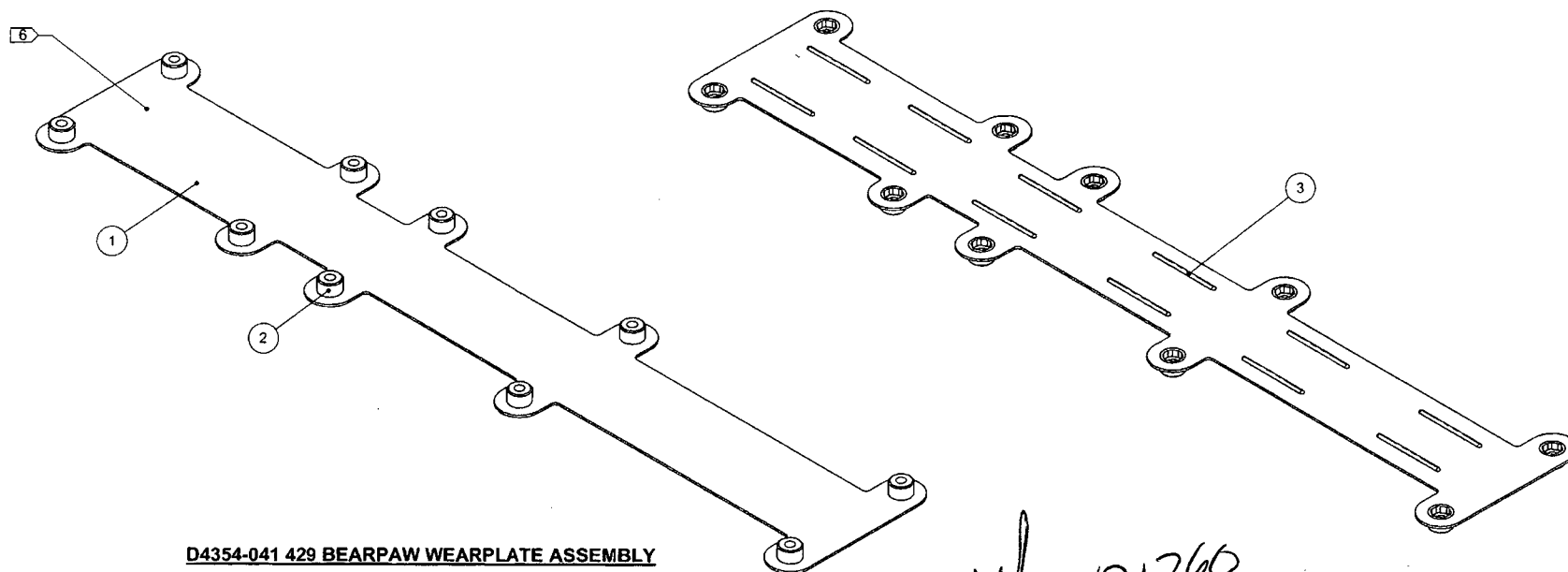
259

4.1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>de</i>		Audited by: <i>38</i>		Preliminary Approval:	
Date: <i>15/07/01</i>		Date: <i>APR 02 2015</i>		Date:	
Rev	Date	Change		Revised by	Approved
A	11.07.26	New Issue	P/O D4354-041	KJ <i>de</i>	<i>AK</i>

ITEM	QTY	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

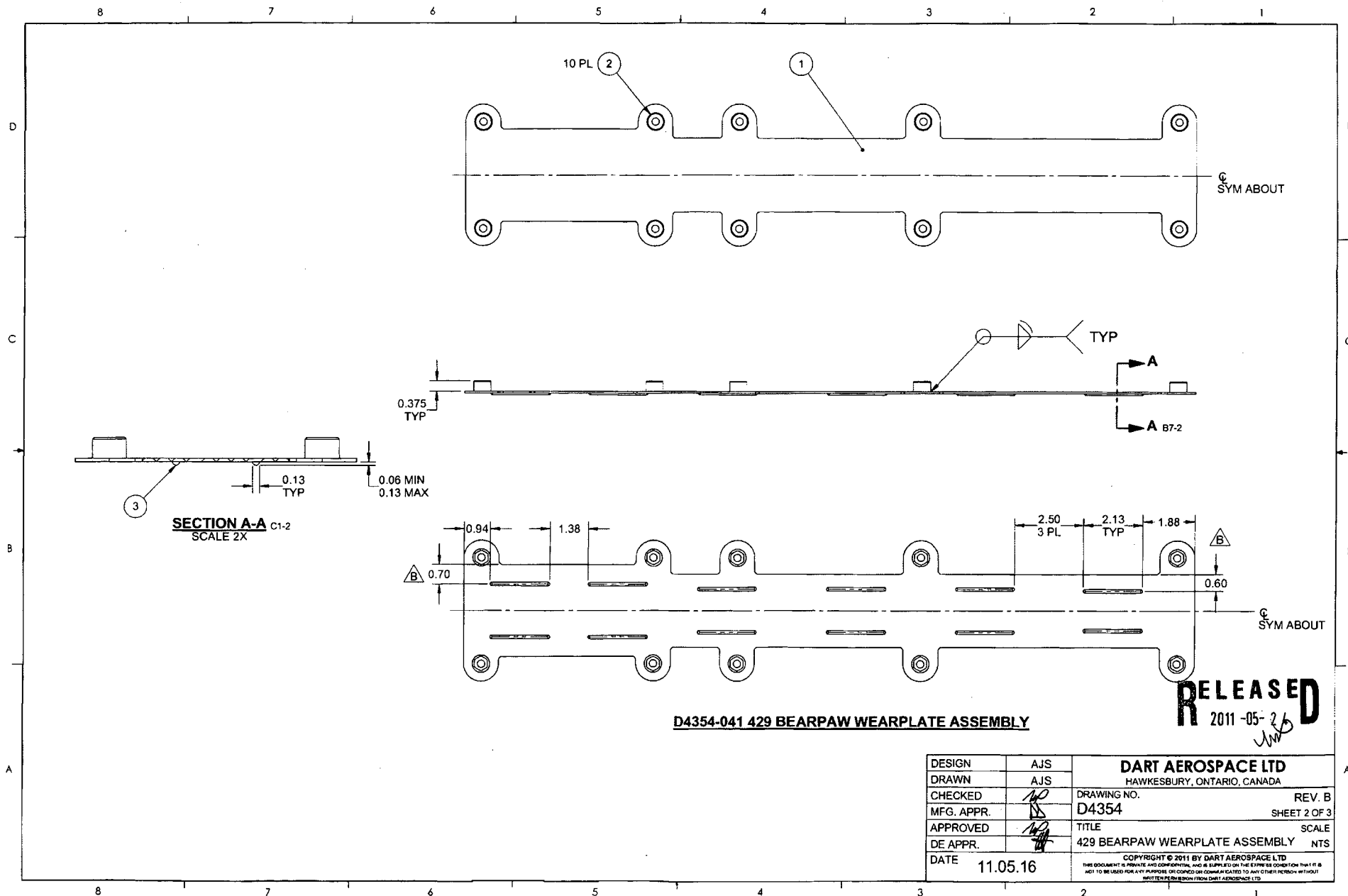
u/o 131260

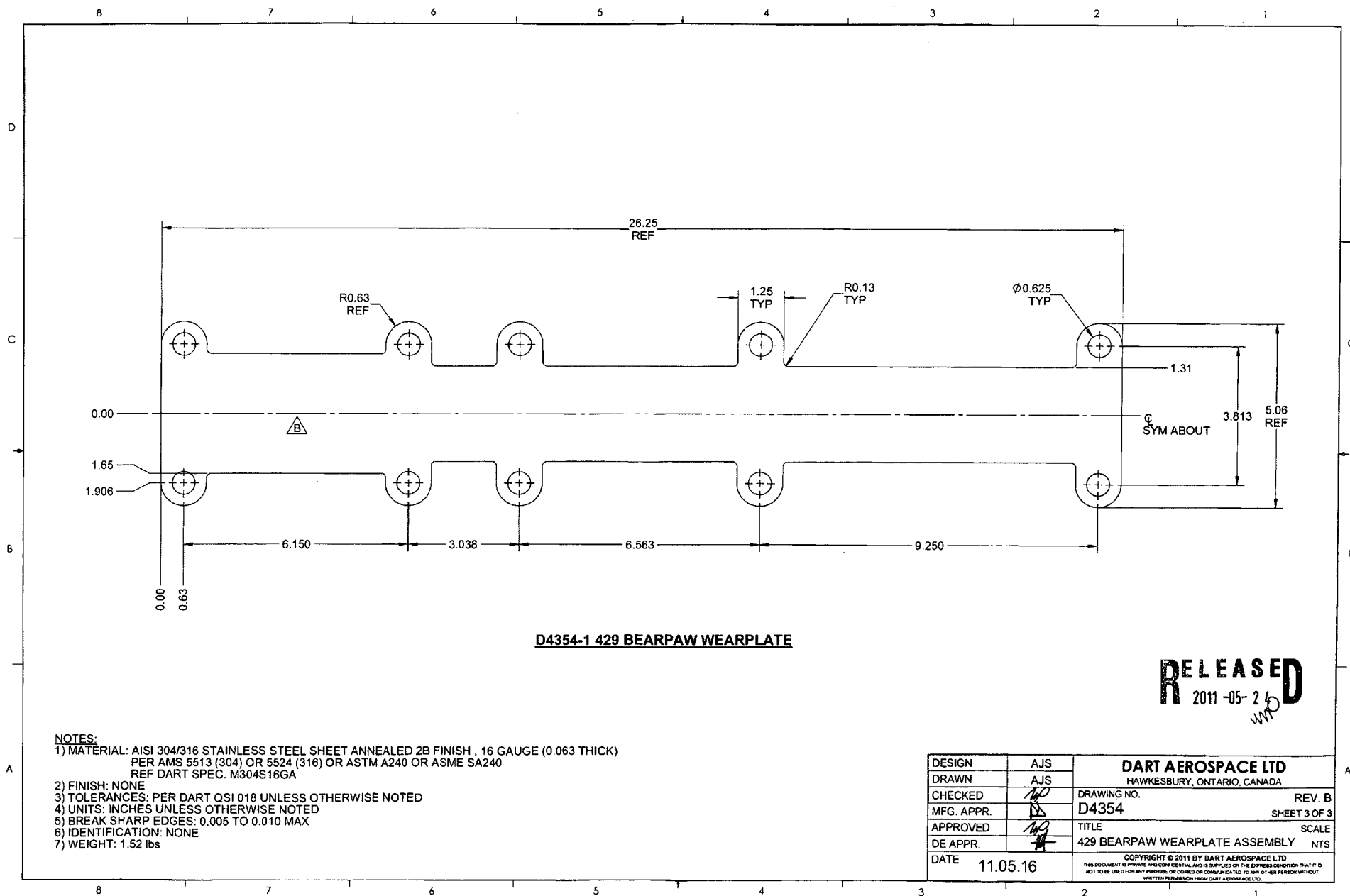
RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3, LIGHTENING HOLES DELETED. SHT 2 ZONE B1 & B6 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW.	AJS	11.05.16
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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D4354-1 429 BEARPAW WEARPLATE

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2011-05-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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